

Date: Monday, 23/03/2009 9:51:30 AM
 User: Jean-Luc Menard

Process Sheet

| | | | | | | |
|--|--|-----------------------|------------------|--------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : STEP (CASTING DETAIL) | | |
| Job Number | : 46661 | | | | | |
| Estimate Number | : 10510 | | | | | |
| P.O. Number | : | | Part Number | : D25763 | | |
| This Issue | : 23/03/2009 | S.O. No. : | Drawing Number | : D2576 REV G | | |
| Prsht Rev. | : NC | | Project Number | : N/A | | |
| First Issue | : / / | Type : MACHINED PARTS | Drawing Revision | : G | | |
| Previous Run | : 43504 | | Material | : | | |
| Written By | : <i>JLM 09-03-23</i> | | Due Date | : 30/03/2009 Qty: 105 Um: Each | | |
| Checked & Approved By | | | | | | |
| Comment | : Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF | | | | | |
| Est Rev:D As per Rev G 07-09-05 JLM Verified By:EC | | | | | | |

Additional Product

| | | |
|---|---|---|
| Job Number: |  | |
| Seq. #: | Machine Or Operation: | Description : |
| 1.0 | D25761 | Step (casting detail)  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 105.0000 Each(s) Pick: Qty Part# Description Batch 1 D2576-1 Step (Casting Detail) <i>45553</i> | | |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1  |
| Comment: HAAS1 1- Machine as per Folio FA332 and Dwg D2576 2- Deburr <i>DT 09/03/25 / J.F. 09/03/27 103</i> | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DT 09/03/25 / J.F. 09/03/27 103</i> | | |
| 4.0 | QC8 | SECOND CHECK  |
| Comment: SECOND CHECK <i>88 09/03/27 103</i> | | |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1  |
| Comment: PACKAGING RESOURCE #1 Identify and Stock <i>Barkley</i> Location: _____ <i>88 09/03/2009 103</i> | | |

Date: Monday, 23/03/2009 9:51:31 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 46661

Part Number: D25763

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/01 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2576-3 PAR #: N/A Fault Category: Prod/Machined parts NCR: Yes No DQA: D Date: 05/04/09
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 05/04/09

| NCR: 46661 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|---|---------------------------------|---------------------------------|------------------|---------------------------|---------------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09/03/27 | 2.0 | Part thickness (Dim. .125") is too thin. Part lift in the Jaws during machining. 2 parts are scrap. | CP 09.03.27 per 051042 | - Scrap parts. - No replace. | J.F. 04/03/27 | SC 09/03/28 | UP 09.03.27 per 051042 | / |
| | | R.C: Process. | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 4666 |
| Description: Step | Part Number: | D2576-3 |
| Inspection Dwg: D2576 Rev: G | | Page 1 of 1 |

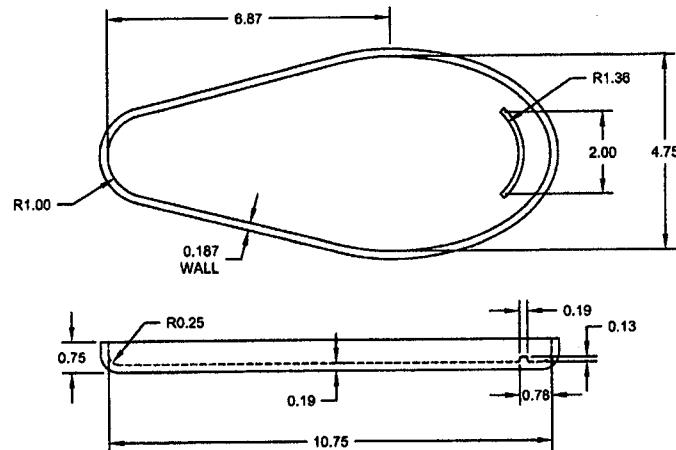
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

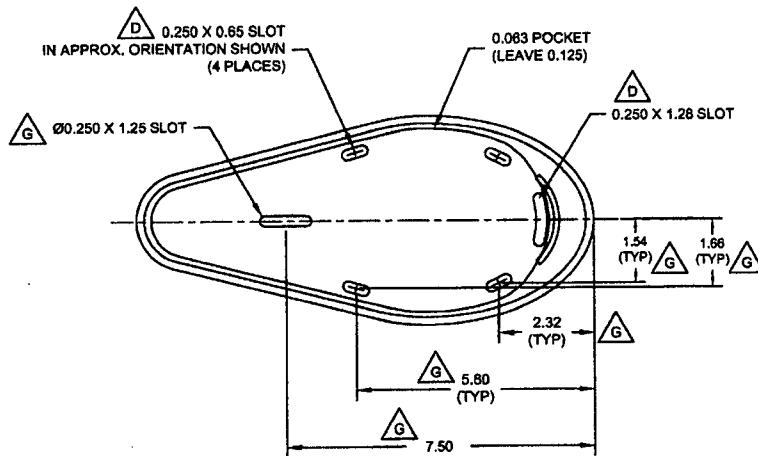
| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | DJP | Audited by: | BP | Prototype Approval: | N/A |
| Date: | 09/03/24 | Date: | 09/03/27 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|----------------------------------|-------------------|-----------------|
| A | 04.02.10 | New Issue | KJ/RF | |
| B | 07.09.06 | Dimensions updated per Dwg Rev G | KJ/JLM | E |

8 7 6 5 4 3 2 1



w/o 4666/

D2576-1 CASTING

RELEASED

07.08.29

D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-356.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

| REV. | DESCRIPTION | BY | DATE |
|------------|--|---|--------------|
| G | - CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM | MB | 07.08.15 |
| F | 7.05 WAS 6.61 | PH | 07.04.17 |
| E | CHANGE 0.50 HOLE LOCATION AND ADD NOTE | RF | 99.09.07 |
| D | CHANGE SLOT SIZE AND LOCATION (TSR A1069) | CP | 99.08.18 |
| C | ADD POCKETS AND SLOTS FOR WELDING | DS | 98.08.18 |
| B | REMOVE POCKETS, ADD HOLE | DS | 98.11.28 |
| A | NEW ISSUE | DS | 98.09.18 |
| DESIGN | 1 | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2576 | SHEET 1 OF 1 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | STEP | 1:3 |
| DATE | 07.08.15 | COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL PURPOSE OR REPRODUCED IN ANY OTHER PAPER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1